Thursday, 16/08/2007 12:01:11 PM

User

Linda Lacelle

Process Sheet

Customer Jot Number : CU-DAR001 Dart Helicopters Services

Drawing Name

: STOP

Estimate Number

: 34033

: 10513

P.C. Number This Issue

:NIA S.O. No. : NIA : 16/08/2007

Part Number Drawing Number : D28052

Prsht Rev. First Issue

Project Number

. D2805 REV. B : N/A

: MACHINED PARTS Type

Drawing Revision

Previous Run

: 33600

Material

Written By

Checked & Approved By

Conment

В Revised Finishing step to Acid etch and

Due Date

: 05/09/2007

Each

Additional Product

Jot Number:



Alodine EC

Seq. #:

Machine Or Operation:

Description:

1.0

6061-T6 Bar 1.5" x 1.5"

Comment: Qty.: 0.2756 f(s)/Unit Total:

8.2688 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/1.1) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch: M102 723

40

2.0

BAND SAW



Comment: BAND SAW

Cut Bar: 3.150" Long

Comment: HAAS CNC VERTICAL MACHINING #1

+0.010/-0.030"

HAAS CNC VERTICAL MACHINING #1

3.0

HAAS1

- 1- Machine as per Folio FA104 and Dwg D2805
- 2- Tumble and Deburr

Identify as D2805-2

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACH

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK



Page 1

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES							
DATE	STEP	PROC	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		. 6						
								<u> </u>

Part No: _	PAR #:	Fault Category:	 NCR: Yes (No	DQA:	Date: 07/08/0	<u> 3</u>
			QA: N/C C	losed:	Date:	

NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section E		Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
				•				
		·						

NOTE: Date & initial all entries

∔Data: Thursday, 16/08/2007 12:01:11 PM Linda Lacelle User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: STOP Part Number: D28052 Job Number: 34033 ob Number: Description: Seq. #: Machine Or Operation: HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 QC3 Comment: INSPECT ALODINE PACKAGING 1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 9.0 Comment: FINAL INSPECTION/W/O RELEASE U 070812 Job Completion

W/O:		WORK ORDER CHANGES	ER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•	PAR #: Fault Category: N	ICR: Ye	s No DQ	A:	Date: _			

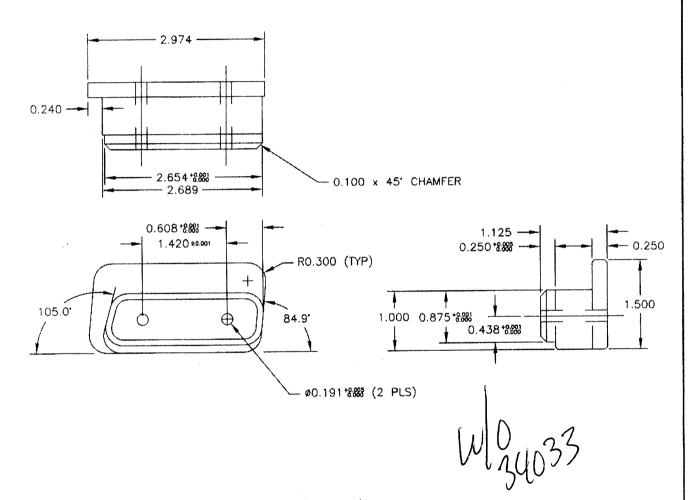
QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		STED Description of NC		Corrective Action Section B				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
	-							

NOTE: Date & initial all entries



DESIG	N	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	(ED	APPROVED	DRAWING NO.	REV. B
	#	 	D2805 SHEET	1 OF 2
DATE			TITLE	SCALE
01.0	3.13		STOP	2:3
Α		00.10.31	NEW ISSUE	
В	·	01 03 13	ADD -3/-4	



D2805-1 (SHOWN) D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED. BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED. MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

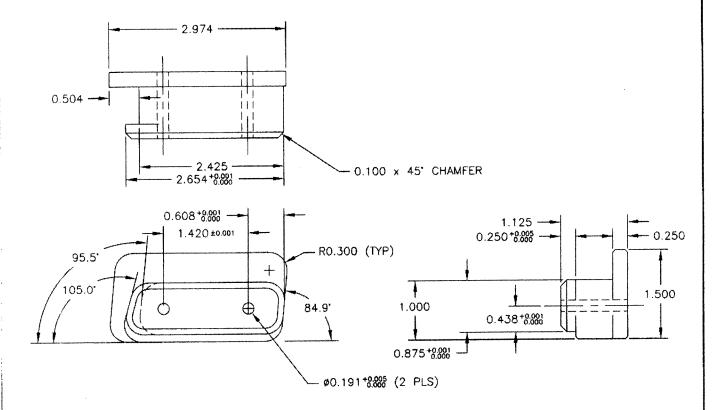
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DESIGN	DRAWN BY		ROSPACE LTD RY, ONTARIO, CANADA
CHECKED,	APPROVEQ	DRAWING NO.	REV. B
d	1	D2805	SHEET 2 OF 2
DATE		TITLE	SCALE
01.03.13		STOP	2:3





<u>D2805-3 (SHOWN)</u> <u>D2805-4 (OPPOSITE)</u>

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED. BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED. MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	24055
		70005 0
Description: Stop	Part Number:	D2805-2
Inspection Dwg: D2805 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010					
0.240	+/-0.010					
0.100 chamfer	+/-0.010					
1.420	+/-0.001					
1.125	+/-0.010					
0.250	+0.005/-0.000					
0.250	+/-0.010			0	as 3360	
1.500	+/-0.010		Na	me	10	(a
1.000	+/-0.010			A -	2360	U
0.875	+0.001/-0.000		11	10		
0.438	+0.001/-0.000					

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.04.26	New Issue	KJ/JLM	

DART AEROSPACE LTD

Description: Stop

Part Number: D2805-2

Inspection Dwg: D2805 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		<u> </u>	
X	First Article		Prototype
L		L	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010	2.973				
0.240	+/-0.010	0.240	N. Parkers			
0.100 chamfer	+/-0.010	0.090				
1.420	+/-0.001	1.420	-			
1.125	+/-0.010	1.123				
0.250	+0.005/-0.000	0,250	-			
0.250	+/-0.010	0246				
1.500	+/-0.010	1.495				
1.000	+/-0.010	1-000				
0.875	+0.001/-0.000	0374				
0.438	+0.001/-0.000	0.438	5			

Measured by:	-prel	Audited by:	J.L.	Prototype Approval:	N/A
Date:	07/08/23	Date:	07/08/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.04.26	New Issue	KJ/JLM X	411